

Date: Friday, 2/23/2007 8:31:26 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 30879	
Estimate Number : 10299	
P.O. Number : <i>N/A</i>	Part Number : D25775
This Issue : 2/23/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2577 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : 30812	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 3/24/2007 Qty: 20 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.02.23	
Comment : Est: F 02.09.24 Re-format KJ/RF	
Est Rev:D Now on Waterjet 06-06-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S16GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 1.0301 sf(s)/Unit Total : 20.6010 sf(s)
 1010/1025 16GA SHEET
 (m1010s16ga)
 Batch: *103788 ml 07 03 16*

(20)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2577
 Dwg Rev: *E*
 Prog Rev: *E*

ml 07 03 16

(20)

2-Deburr if necessary

SAD 07103/24

(20)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: DIMENSIONAL CHECK
 Inspect dimensions per template D2577-5T1

ml 07 03 16

(20)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

MS 07/03/24

(20)


5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

SAD 07103/24 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 07/03/2016
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 8:31:26 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 30879

Part Number: D25775

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on brake using DT8155 and DT8179 as per Dwg D2577

2-Form joggle using DT8157 as per Dwg D2577

3-Identify as D2577-5

SO 07/03/24 20

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/24 20

8.0

POWDER COATING

POWDER COATING



M101601



20X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-h 07/03/26

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m 07/03/26 (20)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP

a.m 07/03/26 (20)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/26

Job Completion



U 07/03/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

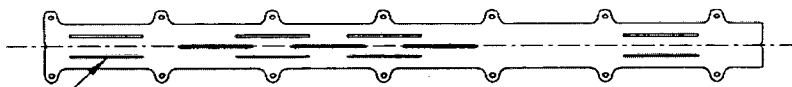
NOTE: Date & initial all entries



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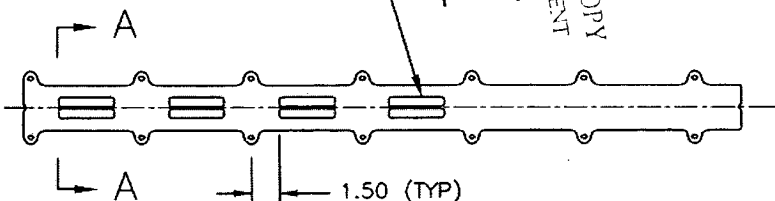
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED	APPROVED	DRAWING NO. D2577	SHEET 1 OF 5
DATE 00.09.22	TITLE WEARSHOE	SCALE 1:10	
A	96.09.16	NEW ISSUE	
B	96.12.04	ADD HARDCOAT WELDS	
C	97.05.30	CHANGE HOLES TO OBROUNDS	
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3	
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176	

7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



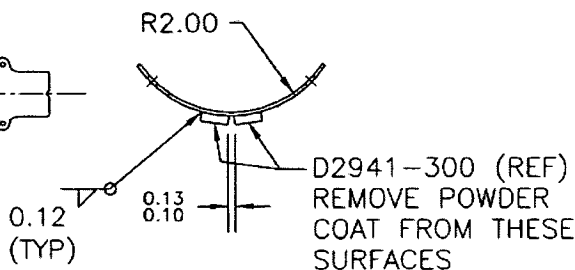
D2577-1 & D2577-3 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2941-300
SHWAYDER WEAPADS
(8 PLACES)



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WORK ORDER
NO 308719

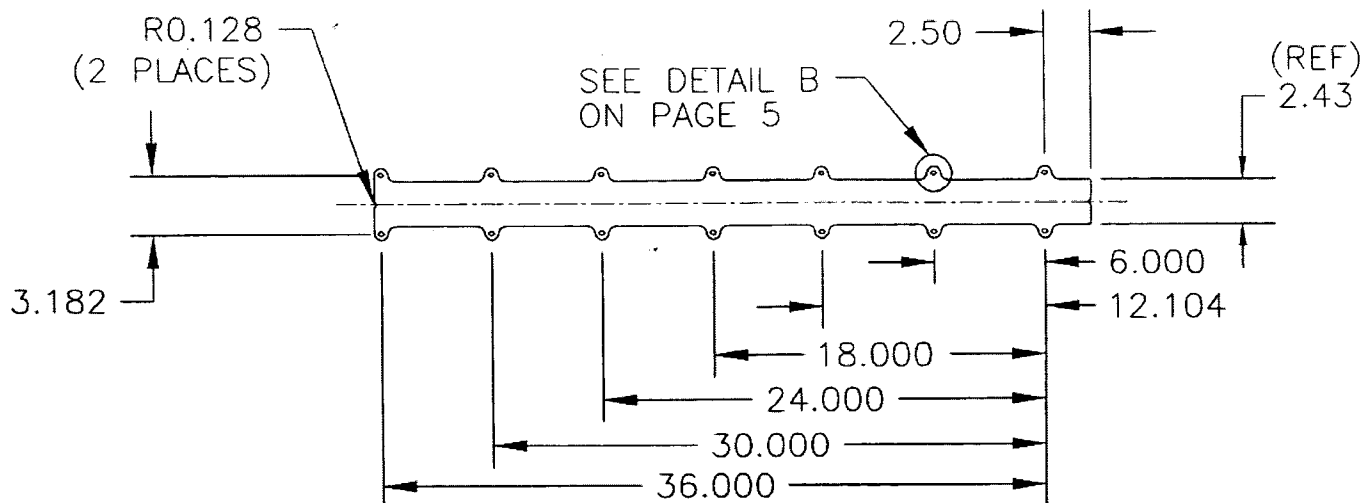
SECTION A-A
SCALE 1:5



D2577-21 & D2577-23 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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DATE 00.09.22		TITLE WEARSHOE
		REV. E SHEET 2 OF 5
		SCALE 1:10



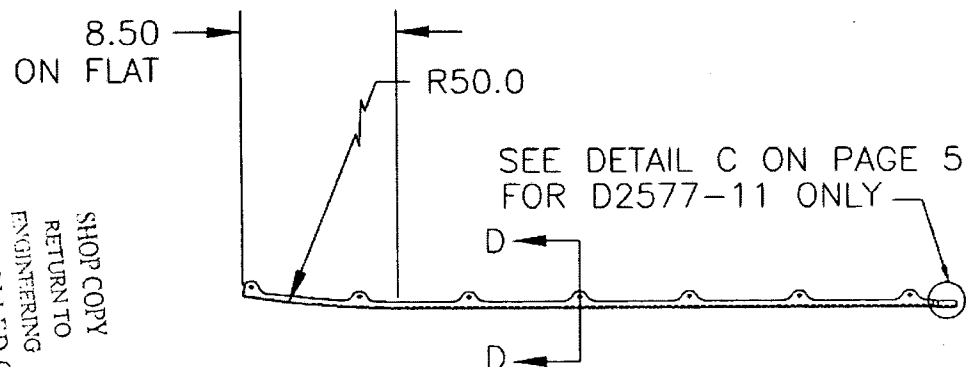
D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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00.09.26

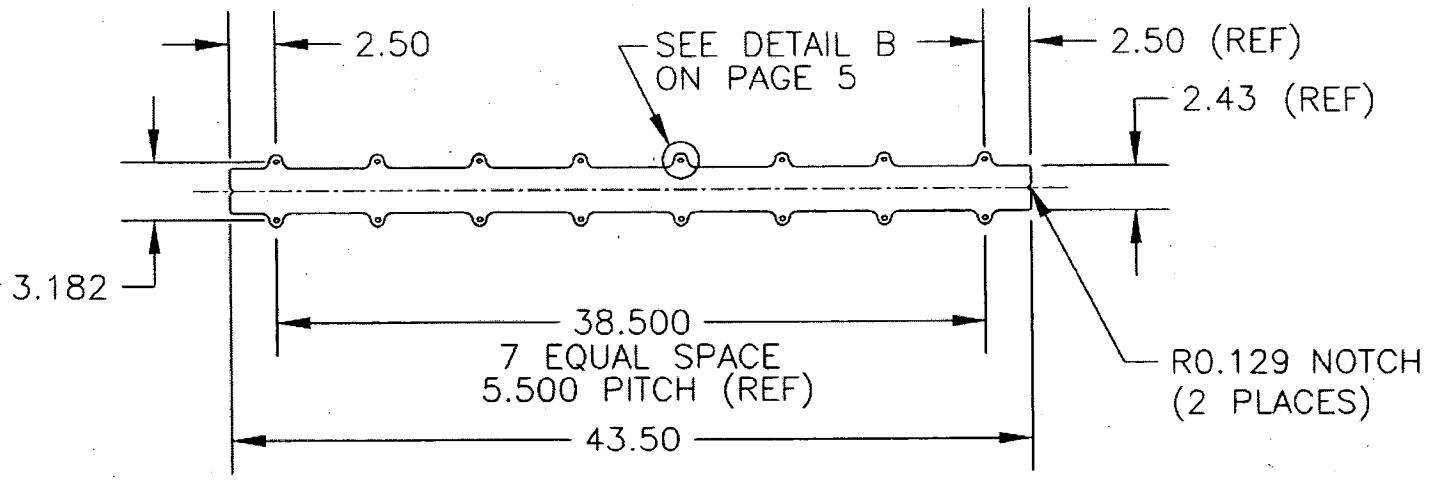
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WORK ORDER
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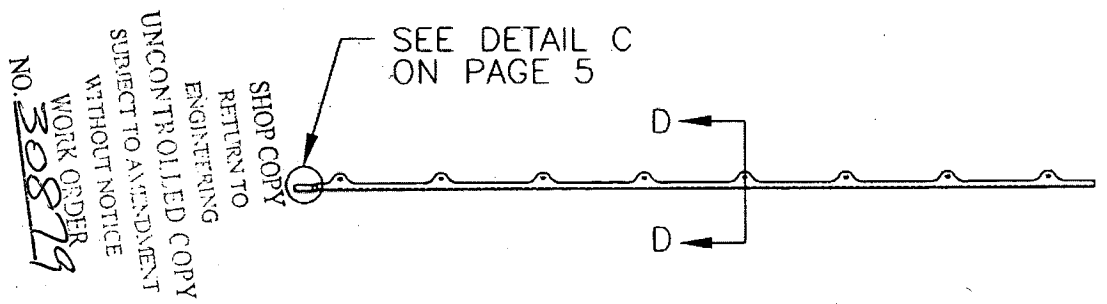
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2577
DATE	00.09.22	TITLE	WEARSHOE	REV. E
		SCALE	1:10	SHEET 3 OF 5

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00.09.26

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



D2577-5 WEARSHOE

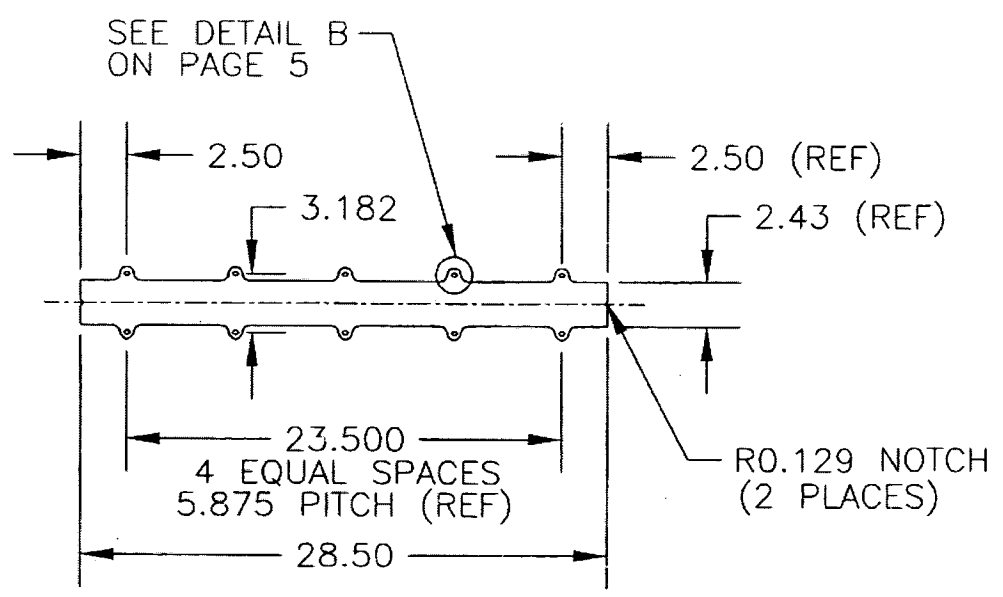
BREAK ALL SHARP CORNERS 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



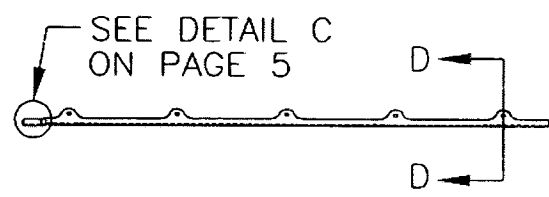
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CHECKED	APPROVED	DRAWING NO.	REV. E
DATE		D2577	SHEET 4 OF 5
00.09.22		TITLE	SCALE
		WEARSHOE	1:10

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00.09.26

D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

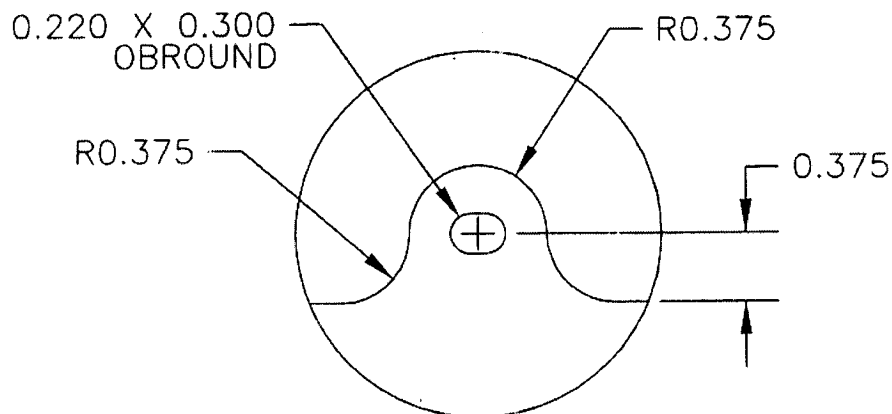
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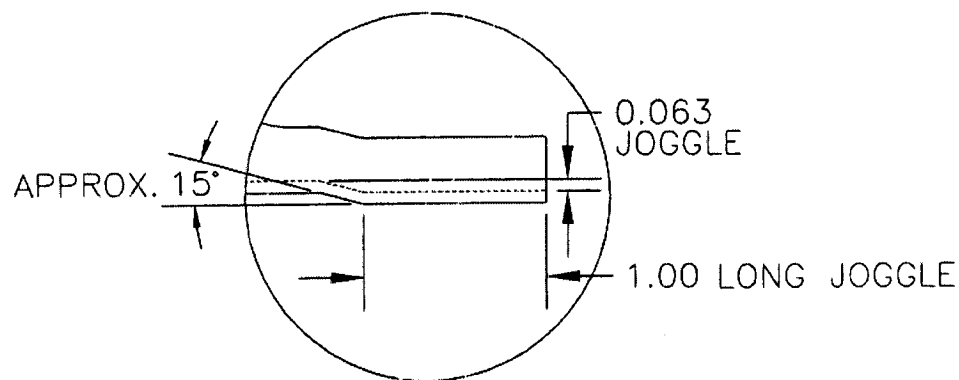
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DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

DETAIL B (SCALE 1:1)

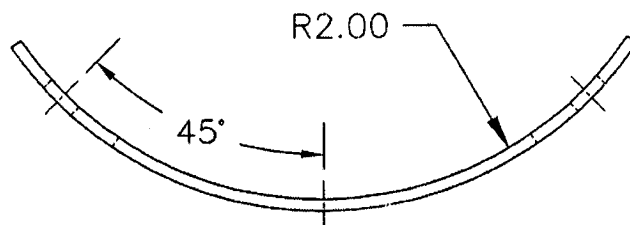
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DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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